

Part 1. Report Cover

Report Number: DLAF041

Report Date: 16 Sep 02

Title: Performance Oriented Packaging Testing of a Grade W6c, Fiberboard Box, Style RSC, 6" x 4" x 8" (ID), with a 1-Quart, Rectangular, Metal Can, (Qty of 1). Surface Shipment Only.

Responsible Individual: Francis S. Flynn

Performing Activity: LOGSA Packaging, Storage,
and Containerization Center
ATTN: AMXLS-AT
11 Hap Arnold Boulevard
Tobyhanna, PA 18466-5097

Performing Activity's Reference(s): TT 10-02; 9HTNR; AMC 13-88

DTIC Distribution: N/A

Requesting Organization:

Defense Logistics Agency
Defense Distribution Center
ATTN DDC J-3/J-4-0
2001 Mission Drive
New Cumberland PA 17070-5000

Requesting Organization's Reference(s):

DLA Memo, 27 Nov 01

Test Results: ___ single X combination ___ composite

Section I. Pre-test Conditions

The following identification schema designates the packaging specimen used for the test(s) indicated.

<u>Specimen No.</u>	<u>Test</u>
A	stack test
A	repetitive-shock vibration test
A	flat onto bottom, drop test
	flat onto long side, drop test
	flat onto top, drop test
	flat onto short side, drop test
	bottom corner, drop test
B	water resistance test

Section II. Summary

A. Drop test	PASS
B. Leakproofness test	N/A
C. Internal pressure test/Hydrostatic pressure test	N/A
D. Stacking test	PASS
E. Vibration standard	PASS
F. Water resistance test	PASS
G. Compatibility test	N/A

Test Results (continued)

Section III. Discussion

A. Drop test: 49 CFR §178.603

Test date(s): 8/26/02

☐ cold conditioned (0° F, 72 hr)
☒ ambient conditions (~72° F)
☐ standard conditions (50% RH & 23° C)

No.	Ht.	Orientation	Results
A	71 "	Flat onto box bottom (3)	Pass/No leaks/rupture; entire contents retained
A	71 "	Flat onto box long side (4)	Pass/No leaks/rupture; entire contents retained
A	71 "	Flat onto box top (1)	Pass/No leaks/rupture; entire contents retained
A	71 "	Flat onto box short side (6)	Pass/No leaks/rupture; entire contents retained
A	71 "	Diagonally onto bottom joint corner (5-2-3)	Pass/No leaks/rupture; minor crushing of the 5-2-3 corner; contents retained completely within the box

Specimen A, a combination packaging consisting of a grade W6c fiberboard box containing one 1-quart metal can. The metal can was filled with water to 98% of maximum capacity (based on weight). Upon examining the box, there was no leakage, rupture, or damage noted, except for minor crushing of the 5-2-3 corner. The can was retained completely within the box.

In conducting the drop test, all five drops (flat bottom, flat long side, flat top, flat short side, and bottom corner) were performed on the same configuration. The decision to use the same container (configuration) for all five drop orientations was based on the relatively minimal damage demonstrated during previous testing of grade W6c, fiberboard boxes with different inner containers or articles. Five drops per configuration exceeds 49 CFR §178.603 requirements, as well as both UN and ASTM recommendations (i.e., one drop on a side or corner per box). The use of one configuration for multiple tests and drops is DOD policy as stated in DLAD 4145.41/AR 700-143/AFJI 24-201/NAVSUPINST 4030.55A/MCO 4030.40A, Packaging of Hazardous Material. Also per this policy, any failed orientation(s) can be repeated using another configuration.

B. Leakproofness test: 49 CFR §178.604

N/A. The leakproofness test was not conducted on the box, because the packaging is not intended for the containment of liquids.

C. Internal Pressure/Hydrostatic Pressure test: 49 CFR §178.605

N/A. Testing for the maintenance of internal pressure is not required for this configuration.

Test Results: Section III (continued)

D. Stacking test: 49 CFR §178.606

Test date(s): 8/23/02

☐ standard conditions (23° C & 50% RH)

☒ ambient conditions (~72° F)

☐ high temperature conditions (104° F)

No.	Length	Type	Load/Force Required	Peak Force	Results	Stability Maintained?
A	24 hr	Static	123 lb	N/A lbf	Pass	Yes

A static top load (136 lbs.) was used for the stack test, because it could hold the load constant for the required 24-hour timeframe. The total top load applied on the empty box was greater than the minimum required for one box based on the outside box height and the gross packaged weight. The top load was to simulate a stack of identical packagings that might be stacked on the packaging during transport.

E. Vibration test: See 49 CFR §178.608.

Test date(s): 8/26/02

No.	Frequency	Duration	Results
A	2.37 Hz	1 hr	Pass. No leakage, rupture, or damage

To be in compliance with U.S. Department of Transportation standards for packagings bearing the United States mark (USA) as a component of the packaging certification marking (49 CFR §173.24a(a)(5)), the vibration test was performed, as a means to determine capability. The test was conducted as prescribed by ASTM D 999, method A2 (Repetitive Shock Test (Rotary Motion)). The test was run for 1 hour, using the fiberboard box packaging. The packaging was tested using a 1,250-lb vibration table (rotary motion) that had a 1-inch vertical double amplitude (peak-to-peak displacement) such that the packaging was raised from the platform to such a degree that a piece of steel strapping (1.6 mm) could be passed between the bottom of the package and the platform.

F. Water resistance (Cobb Method) test (fiberboard): 49 CFR §178.516
As required by the standards for fiberboard boxes, the Cobb Method Test for water absorptiveness was performed on a specimen cut from one box (DLAF037).

Test date(s): 4/3/02

No. specimens felt side (exterior) 5. Average 107 g/m². Highest exterior value was 112 g/m². Lowest exterior value was 101 g/m². All of the samples tested were free of printing.

No. specimens wire side (interior) 5. Average 106 g/m². Highest interior value was 111 g/m². Lowest interior value was 102 g/m².

No. specimens exceeding 155 g/m² 0.

Test Results: Section III (continued)

It should be noted that improper storage and rough handling could break the fibers and abrade the coating of the box, decreasing its ability to resist water absorption. This could result in higher test values. Since commercial boxes are occasionally made with the wire facing (interior) as the exterior side of the box, specimens from both the wire (interior) and the felt (exterior) facings should be tested for water absorptiveness.

G. Compatibility test (plastics packagings only): N/A.

Test Personnel

The following personnel performed the aforementioned testing, or had a role in the testing, evaluation, and/or documentation, as reported herein-- Richard D. LaFave, Bruce W. Samson, Timothy L. Reimann, and Karen K. Kimsey

References

A. Title 49 Code of Federal Regulations, Parts 106-180, Fall 2002, current as of 10 Jul 02

B. International Air Transport Association Dangerous Goods Regulations, 40th edition, 1 January 1999

C. ASTM D 4919, Specification for Testing of Hazardous Materials Packagings.

D. ASTM D 999, Standard Method for Vibration Testing of Shipping Containers.

E. ASTM D 951, Standard Test Method Water Resistance of Shipping Containers by Spray Method.

F. TAPPI Standard: T 441 Water Absorptiveness of Sized (Non-Bibulous) Paper and Paperboard (Cobb Test).

G. Recommendations on the Transport of Dangerous Goods, sixth revised edition, United Nations, New York, 1990.

H. DLAD 4145.41/AR 700-143/AFJI 24-201/NAVSUPINST 4030.55A/MCO 4030.40A, Packaging of Hazardous Material, 23 Jul 96

I. AFJMAN 24-204/TM 38-250/NAVSUP PUB 505/MCO P4030.19G/DLAI4145.3, Preparing Hazardous Materials for Military Air Shipments, 1 Mar 97

Test Results: Section III (continued)

Equipment

Item	Manufacturer	Serial No.	Calibration Expiration Date
1,250-lb vibration table	L.A.B Skaneateles, NY	8120179	<i>see note</i>
5,000-lb compression tester	L.A.B Skaneateles, NY	1107050	4/03
drop tester	Lansmont Monterey, CA	M12906	N/R
Cobb Sizing Tester	Teledyne Curley Troy, NY	4180-A	N/R

Note. Equipment is calibrated in accordance with International Safe Transit Association test equipment verification requirements.

Appendix A

Test Applicability

Pass/fail conclusions were based on the particular fiberboard box specimens, test loads, and the limited quantities submitted for test. Extrapolation to other materials, other manufacturers, other applications, different inner packagings, container sizes, or lesser inner quantities is the responsibility of the packaging design agency or applicable higher headquarters. Extrapolation of test results based on less than the minimum recommended number of test specimens is also the responsibility of the packaging design agency or applicable higher headquarters.

Testing was performed per *Title 49* Code of Federal Regulations.

Performance testing was undertaken and completed at the request of an agency responsible for shipment of the dangerous good(s). The completion of successful required performance tests does not, by itself, authorize the marking and transportation of the dangerous good(s). Applicable modal regulations should be consulted concerning the relationship of performance testing completed and the dangerous good(s).

The required performance tests are intended to evaluate the performance of the packaging components. The criteria used to evaluate packaging performance is whether the contents of the packaging are retained within the outer packaging, should damage to the outer packaging occur, and secondly, if any inner packaging of hazardous materials leaks, ruptures, or is damaged so as to affect transportation safety. The successful completion of the required tests does not ensure the undamaged delivery or survivability of the actual commodity/item. Separate testing is necessary to assure the stability of any explosive item.

Before a configuration can be certified by the person(s) authorizing shipment, the appropriate packaging for the particular hazardous materials and mode of transportation must be determined, and the item(s) must be prepared for shipment per applicable regulations. The chosen configuration must have been performance tested in accordance with the size, the shape, and the weight constraints posed by the configuration to be certified. The testing reported herein should not be construed as blanket certification of any configuration that simply uses the performance tested outer fiberboard box. Packaging paragraphs apply.

Appendix B

Test Data Sheet

Section I. Test Product

Physical State: ___ solid X liquid ___ gas ___ aerosol

Name: Water

Amount Per Container (Configuration):

1 quart, rated; 2.08 lb; 2.38 lb, packed

Gross Weight: 4.00 lbs.

Section II. Test Parameters

Drop Height: Ref: 49 CFR §178.603

___ 1.8 m; 71 in. (PG I, II, & III, SG ≤1.2 or solids)

___ 1.2 m; 47 in. (PG II & III, SG ≤1.2 or solids)

___ 0.8 m; 32 in. (PG III, SG ≤1.2 or solids)

X from-- PG I: SG x 1.5 m x 59.06 in./m

71 in. PG II: 1.8 (SG) x 1.0 m x 39.37 in./m

PG III: SG x 0.67 m x 26.38 in./m

Stacking Weight Formula, Liquids - DLA

Variables

Inputs

h	height, drum/box	8.5		
n	# stacked containers	XXXXXXXX	13.883	
w1	weight, drum/box	0.46		
w2	weight, bottle/can	0.3		
w3	weight, ring/pad	1.15		
q1	# inner containers	1		
v1	max. volume, 1 inner container	0.25		
v	total volume	XXXXXXXX	0.25	
w4	weight, item (unpacked)	2.08		
W5	weight, absorbent	0		
W	total weight	XXXXXXXX	4	
C	constant	1		
A1	Stacking weight-PG I	XXXXXXXX	83.0	83
A2	Stacking weight-PG II	XXXXXXXX	98.7	99
A3	Stacking weight-PG III	XXXXXXXX	122.3	123

NOTE: A1 = $(n-1) * (w + (1.2 * v * 8.3 * 0.98)) * (c)$, Packing Group I
A2 = $(n-1) * (w + (1.8 * v * 8.3 * 0.98)) * (c)$, Packing Group II
A3 = $(n-1) * (w + (2.7 * v * 8.3 * 0.98)) * (c)$, Packing Group III

A1 = stacking weight in pounds, PG I

A2 = stacking weight in pounds, PG II

A3 = stacking weight in pounds, PG III

n = $(118/h)$, minimum number of containers that when stacked, reach a height of 3 m

w = $w1 + (w2 * q1) + (w3 * q1) * w5$, total weight in pounds

v = $v1 * q1$, total volume

C = either 1.5 (the compensation factor that converts the static load of the stacking test into a load suitable for dynamic compression testing), or 1.0 (static top load)

Appendix B (Continued)

Section III. Equivalencies of Liquids

	Specific Gravity ¹	Total (Each) Amount per Container	Gross Weight (pounds)	Gross Weight (kilograms)
water*	1.0	2.08 lb	4.00	1.82
PG I	1.2	2.50 lb	4.50	2.04
PG II	1.8	3.74 lb	5.60	2.54
PG III	2.7	5.62 lb	7.50	3.40

Note 1. Equivalent specific gravity derived from drop height as follows-- PG factor x density (or SG) = drop height, thus

SG = drop height/PG factor (49 CFR §178.603)

PG I: 1.5 m x SG = 1.8 m, thus SG = 1.2

PG II: 1.0 m x SG = 1.8 m, thus SG = 1.8

PG III: 0.67 m x SG = 1.8 m, thus SG = 2.7

Unless otherwise computed for more dense liquids, water (SG = 1) represents a solution having a specific gravity of 1.2 or less.

Appendix C

Packaging Data Sheet

Section I. Exterior Shipping Container

Packaging Category: ____ single X combination ____ composite

UN Type: Fiberboard boxes (49 CFR §178.516) UN Code: 4G

Specification No.: ASTM-D5118; Style RSC; .46 lbs.;
6" x 4" x 8" (ID); 6½" x 4½" x 8½" (OD)

Manufacturer: Packaging Control Corp., York, PA 17402

Date(s) of Manufacture: August 2002

Closure Method: The fiberboard box was sealed (7 strip method) using 2" A-A-1830 clear tape. (See drawing)

Additional Description:

a. Fiberboard pads (c flute, 200 Burst), were first placed in the box on all sides and the box bottom. Approximate sizes of the top and bottom pads were 6 x 4 inches. Ten side pads were approximately 6 x 7 inches and ten side pads were 2.5 x 7 inches. The 1-quart can was first placed in a 14 x 16 inch, 4-mil, polyethylene bag and then placed on the bottom pad. The top pad was placed on the bag enclosed metal can and the box was sealed using the closure method described above.

Bag Manufacturer: Quality Packaging Systems of Warren, Inc.,
24260-2 Mound Road, Warren, MI 48091-5324

Appendix C (Continued)

Section II. Inner Packaging/Article

Quantity of Inner Containers: 1

Nominal Capacity per Inner Container: 1 quart

Specification Type and Number(s): N/A

NSN: N/A

Type/Materials: one quart metal can with screw cap and solvseal-lined cap (distributor's description)

Manufacturer/Distributor: Freund Can Company
Chicago, Illinois 60620 (box marked)

Manufacturer/Distributor Part Number(s): 1912A

Contract and Purchase No(s): Not marked

Date of Manufacture: N/A

Tare Weight (empty): 0.30 lb;

Dimensions: $7\frac{5}{16}$ in. in height (OD)
 $2\frac{3}{8}$ in. in diameter (OD)
 $4\frac{9}{16}$ in. in length (OD)

Closure (Method/Type): cap with coated liner

Closure Specification Number(s): N/A

Closure Manufacturer/Distributor and Part No(s): N/A

Closure Dimensions: $1\frac{1}{4}$ in. (ID), cap

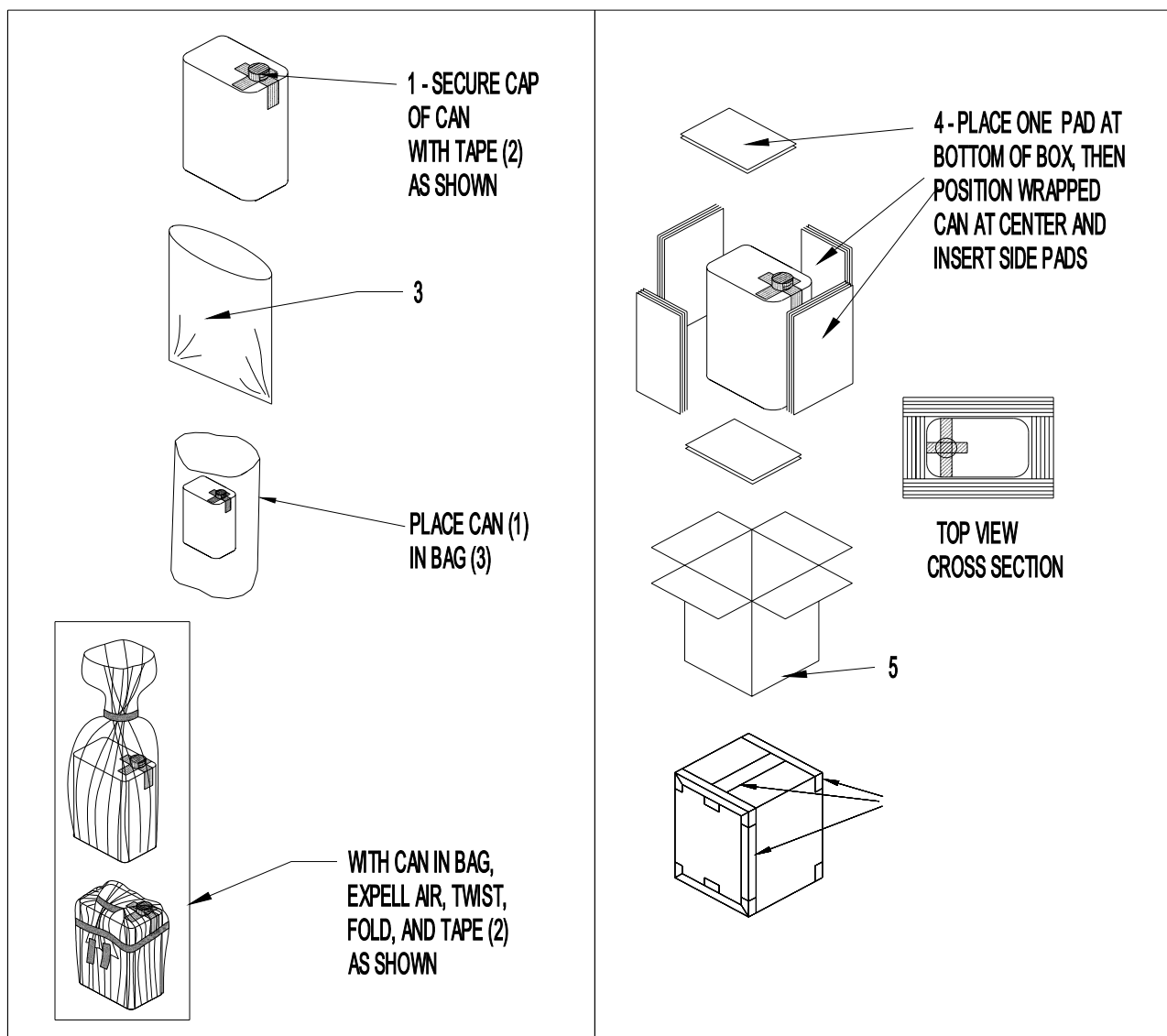
Secondary Closure: Filament-reinforced tape (1 pc)

Rationale

The equivalent of Packing Group II & III testing was requested for a 6- by 4- by 8-inch corrugated fiberboard box having as the intended contents one 1-quart, metal can. The configuration to be tested is intended to be applicable to a large assortment of liquid products contained in 1-quart metal cans. For lesser volumes, variations to testing requirements can be found in 49 *CFR* §178.601(g).

One combination packaging made to the above described configuration was subjected to drop and vibration testing as prescribed in ASTM D 4919. These tests are designed to simulate the shock and vibration a package (configuration) may encounter when being shipped worldwide by truck, rail, or ocean going transport. The order of testing was vibration, then drop testing. Prior to the rough handling testing of the packed box, static loading was performed on an empty box. This is a U.S. DOT approved method of stack testing, especially when the combination packaging has wide applications. A separate box was used for water absorptiveness testing of the fiberboard.

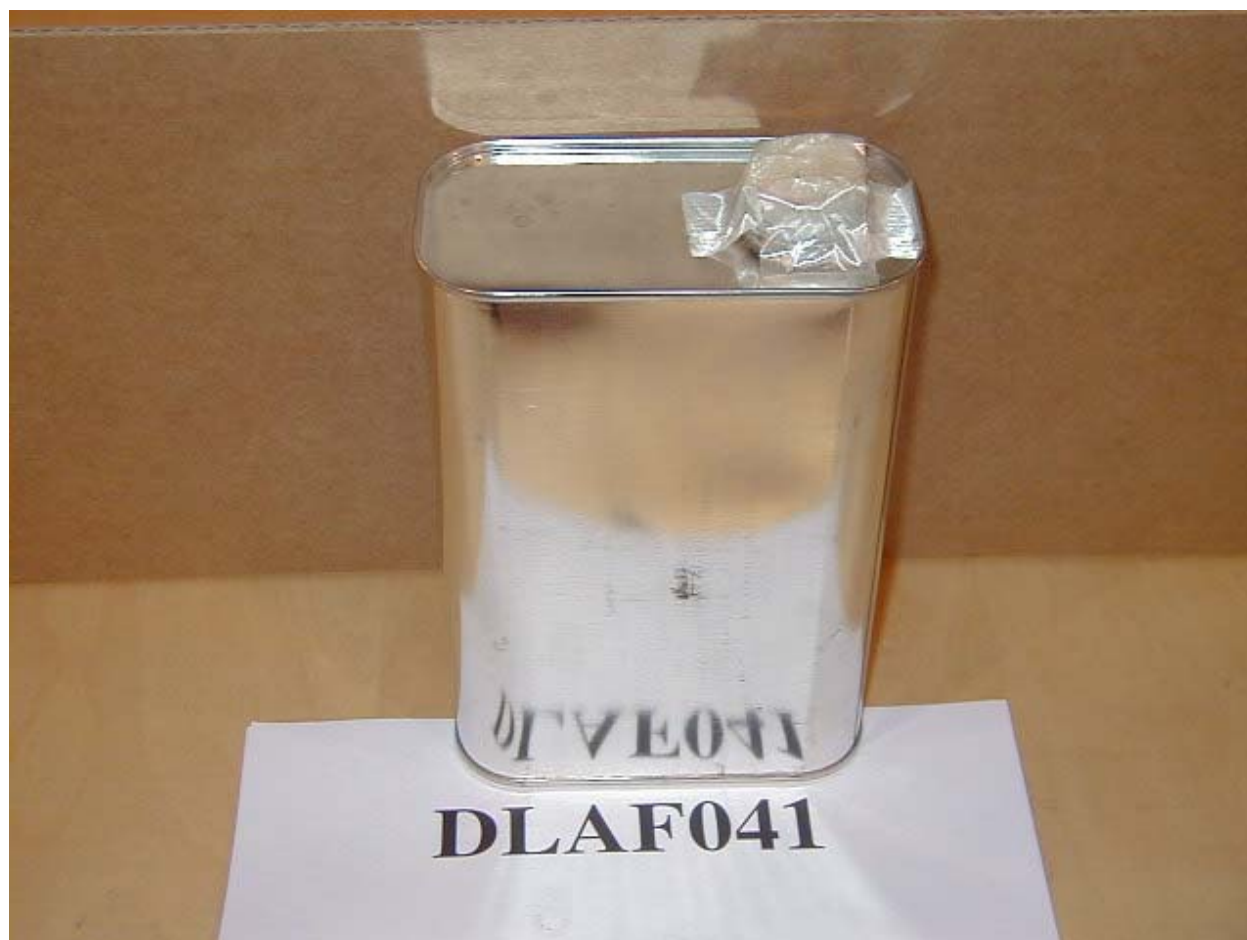
Appendix D (Continued)
Drawing



ITEM	DESCRIPTION	DLA02041
1	1-QUART, RECTANGULAR, METAL CAN WITH CAP, QTY. 1	
2	1-INCH WIDE, PRESSURE-SENSITIVE TAPE, FILAMENT-REINFORCED, IAW ASTM D5330, TY II	
3	4-MIL POLYETHYLENE BAG	
4	FIBERBOARD PADS (C FLUTE, 200 BURST), APPROXIMATE SIZES 6.0 X 4, 6 X 7, 2.5 X 7 IN.	
5	FIBERBOARD BOX, ASTM D5118, STYLE RSC, GRADE W6c, NSN: 8115-00-190-4888, 6 X 4 X 8 IN.	
6	2-INCH WIDE, PRESSURE-SENSITIVE TAPE, IAW ASTM D 5486, TY II, NSN: 7510-00-266-6715	

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Appendix D (Continued)



RN: DLAF041

Appendix D (Continued)

